

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 74.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015703**Date Inspected:** 13-Jul-2010**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Goodwin Steel, UK**OSM Arrival Time:** 815**OSM Departure Time:** 1445**Location:** Trentham, UK**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:** **Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:** **Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:** **Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:** **Yes No N/A****Delayed / Cancelled:** **Yes No N/A****Bridge No:** 34-0006**Component:** Cable Band**Summary of Items Observed:**

The following report is based on METS observations at Goodwin International, Trentham, UK on this date:

Mr. Alan Bentley pointed out to the QA Inspector that casting GG29438-2, 5540-B10-1-M has an area of reduced thickness at the bottom center of the casting that reduces the wall thickness to below the allowable of 35 mm. This is to be weld repaired. This condition was identified at layout.

The QA Inspector observed Mr. S. Young performing a welder qualification test. Mr. C. Ellis, Welding Engineer, Goodwin International was representing the manufacturer in performance of this qualification. Mr. Young was using WPS04-0120F4G. The qualification was performed in the horizontal position. Mr. Young was previously qualified in the flat and vertical positions. The plate being used is 1/2" EN10025-2:2004 S355J2-N. It is identified with heat number 89076. The heat number was observed to have been stamped into the qualification coupons. It would appear that this material does not comply with any ASTM or international standard recognized by ASME Section IX. Further qualification testing was suspended. The QA Inspector had a discussion with Mr. S. Young Welding Supervisor and Mr. C. Ellis, Goodwin International Weld Engineer, concerning the material. Mr. Ellis elected to halt welder qualification testing.

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## WELDING INSPECTION REPORT

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### SHOP REVIEW:

EPP-28, GG29436-8 and GG29437-8, a B9 Type 1 cable band was observed being machined at the Webster and Bennet machining center. The rough bore is being machined.

Casting GG29436-1, 5540-B9-1-M was observed at the layout table.

### Summary of Conversations:

Relevant conversations are documented above

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Riegler,Randy	Quality Assurance Inspector
<b>Reviewed By:</b>	Edmondson,Fred	QA Reviewer

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